

Work Order ID 61313

Tuesday, August 17, 2010 8:18:25 AM



Page 1

Item ID: D350-748-241TRN

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Turning Detail

Start Date: 8/17/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 8/24/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 10-8-17 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-748-241	Rev E								
100		0.00							
	MORI SEIKI CNC LATHE LARGE								
Mori Seiki	Memo	0.00							
Mori Seiki CNC Lathe Large	1-Fill tube with sand & install plugs on both ends as per Folio FA647 2-Turn first side as per Folio FA647 3- File transition lines smooth.								
110		0.00							
	QC1- Inspect dimensions to dimension sheet								
QC	Memo	0.00							
Quality Control									
120		0.00							
	MORI SEIKI CNC LATHE LARGE								
Mori Seiki	Memo	0.00							
Mori Seiki CNC Lathe Large	1-Turn second side as per Folio FA647 2- File transition lines smooth. 3-Scribe part # as per Dwg D350-748-241								

Q.M. 10-08-18 180

Q.M. 10-08-18 180

Q.M. 10-08-18 180

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61313

Tuesday, August 17, 2010 8:18:26 AM



Page 2

Item ID: D350-748-241TRN

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Setup Start



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Stop



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Required Date: 8/24/2010 Req'd Qty: 1.00



Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC1- Inspect dimensions to dimension sheet Memo	0.00 0.00							Q.m 10-08-18 ①
140 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							1 - AWM 10-08-18
150 Crosstubes Crosstubes	Large Fab Memo Grind machining marks.	0.00 0.00							1 - AWM 10-08-18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Tuesday, August 17, 2010 8:18:26 AM



Accept

**Setup Start**

Stop



10-700

Cust Item ID:

1. **NAME** _____
 2. **ADDRESS** _____
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Customer:

Reference:

Run Start



Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Date: _____ **SPC (Y/N):** _____ **Date:** _____

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

0.00



Memo

0.00

Issue P/O: 12699
Heat Treat to min 180 KSI As per Dwg D350-748-241
Sand Blast tube after Heat Treat
Possible Supplier: Vac Aero
Ensure Certificate of Conformity is attached

CL 10/10/06 ①

0.00



Memo

0.00

Ensure certificate of conformaty is attached

Page 10

0.00



Memo

0.00

Quality Control

8/10/15

f

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

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Cust Item ID:

Required Date: 8/24/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and stock in kanban rack Location: <u>LT</u>		SAD	10-12-06					
200 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/12/07

W 10.12.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, August 17, 2010 8:18:25 AM

Page 1

Work Order ID: 61313



Parent Item: D350-748-241TRN



Parent Item Name: Crosstube Turning Detail


Start Date: 8/17/2010

Required Date: 8/24/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 08-03-06 DD verified by:ec
IPP Rev B Removed polish 08.04.02 EC verified by : DD
IPP Rev C Removed LPS-3 08.06.23 Ec verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6018-125		Manufactured	No			120	Each	44.0000	1	1			
													
Crosstube Material													



am 10-08-18 @

Location

Loc Qty

Loc Code

LG

44

32913

44

1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 61313
Description: Crosstube Assembly (AS350/355 High Aft)		Part Number: D350-748-241
Inspection Dwg: D350-748-241 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.240	/	Caliper a.m.-04	
	2.180	+0.005/-0.000	2.185	/		
	2.180	+0.005/-0.000	2.185	/		
	2.208	+0.005/-0.000	2.213	/		
	2.234	+0.005/-0.000	2.239	/		
	2.253	+0.005/-0.000	2.258	/		
	2.272	+0.005/-0.000	2.277	/		
	2.299	+0.005/-0.000	2.304	/		
	0.063	+/-0.010	0.063	/		
	4.26	+/-0.030	4.260	/		
	R0.063	+/-0.010	R0.063	/		
	R0.50	+/-0.030	R0.500	/		
SIDE B	2.240	+0.005/-0.000	2.240	/	Caliper a.m.-04	
	2.180	+0.005/-0.000	2.185	/		
	2.180	+0.005/-0.000	2.185	/		
	2.208	+0.005/-0.000	2.213	/		
	2.234	+0.005/-0.000	2.239	/		
	2.253	+0.005/-0.000	2.258	/		
	2.272	+0.005/-0.000	2.277	/		
	2.299	+0.005/-0.000	2.304	/		
	0.063	+/-0.010	0.063	/		
	4.26	+/-0.030	4.260	/		
	R0.063	+/-0.010	R0.063	/		
	R0.50	+/-0.030	R0.500	/		
	122.70	+/-0.060	122.700	/	Tape measure a.m.-01	

Measured by: a.m.	Audited by: S for AWM	Prototype Approval:	N/A
Date: 10.08.18	Date: 10/10/18	Date:	N/A
Rev	Date	Change	Revised by Approved
A	07.01.17	New Issue (P/O D350-748-201)	KJ/JLM

W/O:		WORK ORDER CHANGES					
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Item	Qty -241	Part Number	Description
1	X	D350-748-241	CROSSTUBE ASSEMBLY (AS 350/355 HI AFT)
2	1	D6018-125	CROSSTUBE
3	2	D3502-1	SUPPORT
4	2	D2856-400-710	ABRASION STRIP
5	1	AEIS-1032-225	INSERT
6	1	NAS1149D0363J	WASHER (OR AN960JD10)
7	2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
8	1	MS27039-1-10	SCREW

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6018-125
FINISHED LENGTH = 122.700±0.06
- 2) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D350-748-241" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 29.85 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.297 HOLE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING.
- 12) INSTALL D2856-400-710 ABRASION STRIPS WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 13) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 14) TORQUE CLAMPS 60 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
2009-10-29

REV.	DESCRIPTION	BY	DATE
E	REVISE GENERAL NOTES; UPDATE TO CURRENT STANDARDS; RELOCATED FLAG #6 PER PAR 08-046 (ZN A8-3); ADD TOLERANCES (ZN C6-3, D2-3)	RF	09.09.30
D	MAG. PARTICLE AND CAD PLATE AS MFD.	CP	06.10.31
C	ADD CAD PLATING	CP	06.08.14
B	ADD D6018-125 & PRIME AND PAINT	CP	06.06.30
A	NEW ISSUE	CP	06.03.31
DESIGN			
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	09.09.30		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D350-748-241	REV. E SHEET 1 OF 4
TITLE CROSSTUBE (AS 350/355 HI AFT)	SCALE NTS
COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Dart Aerospace Ltd

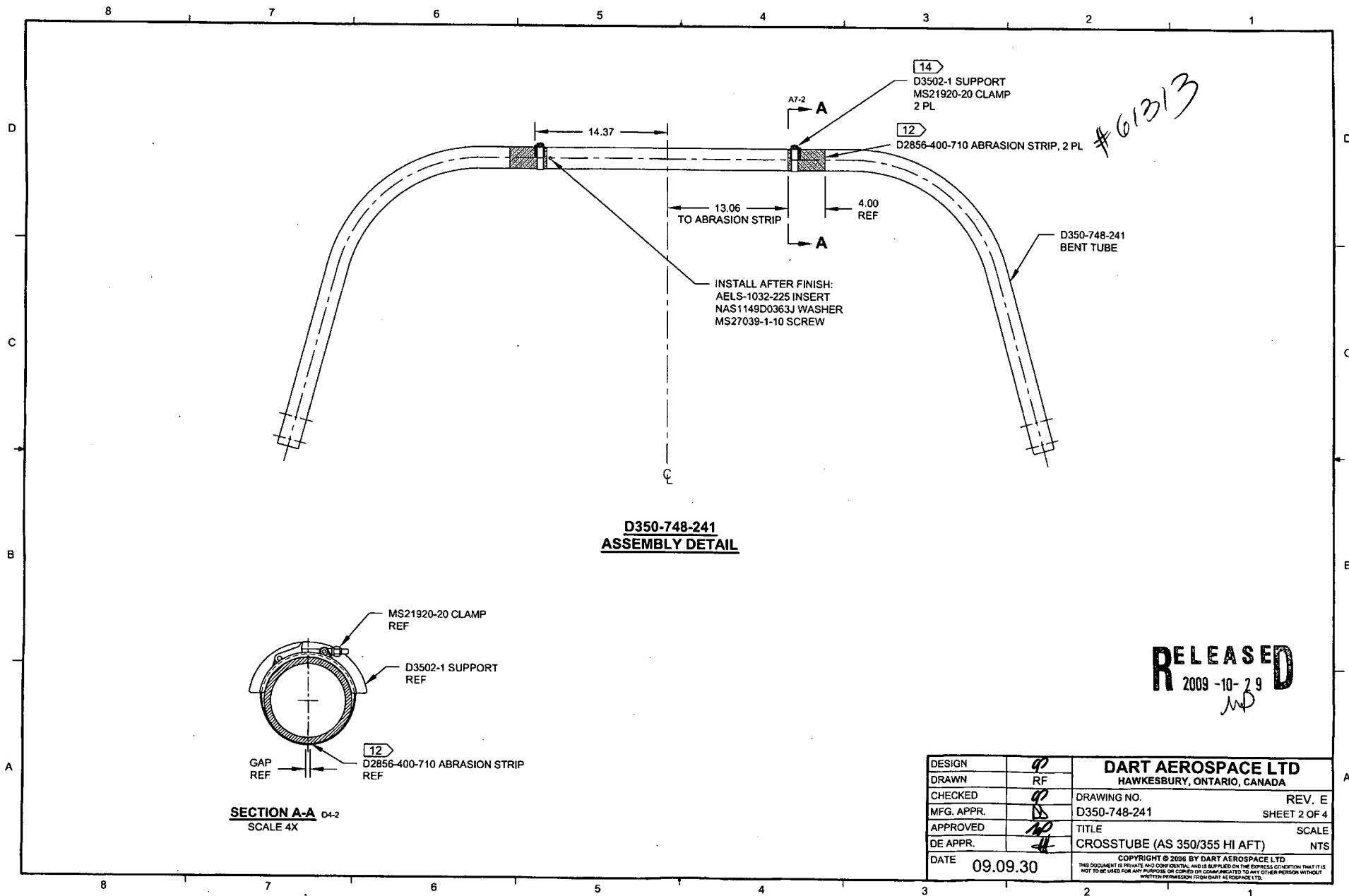
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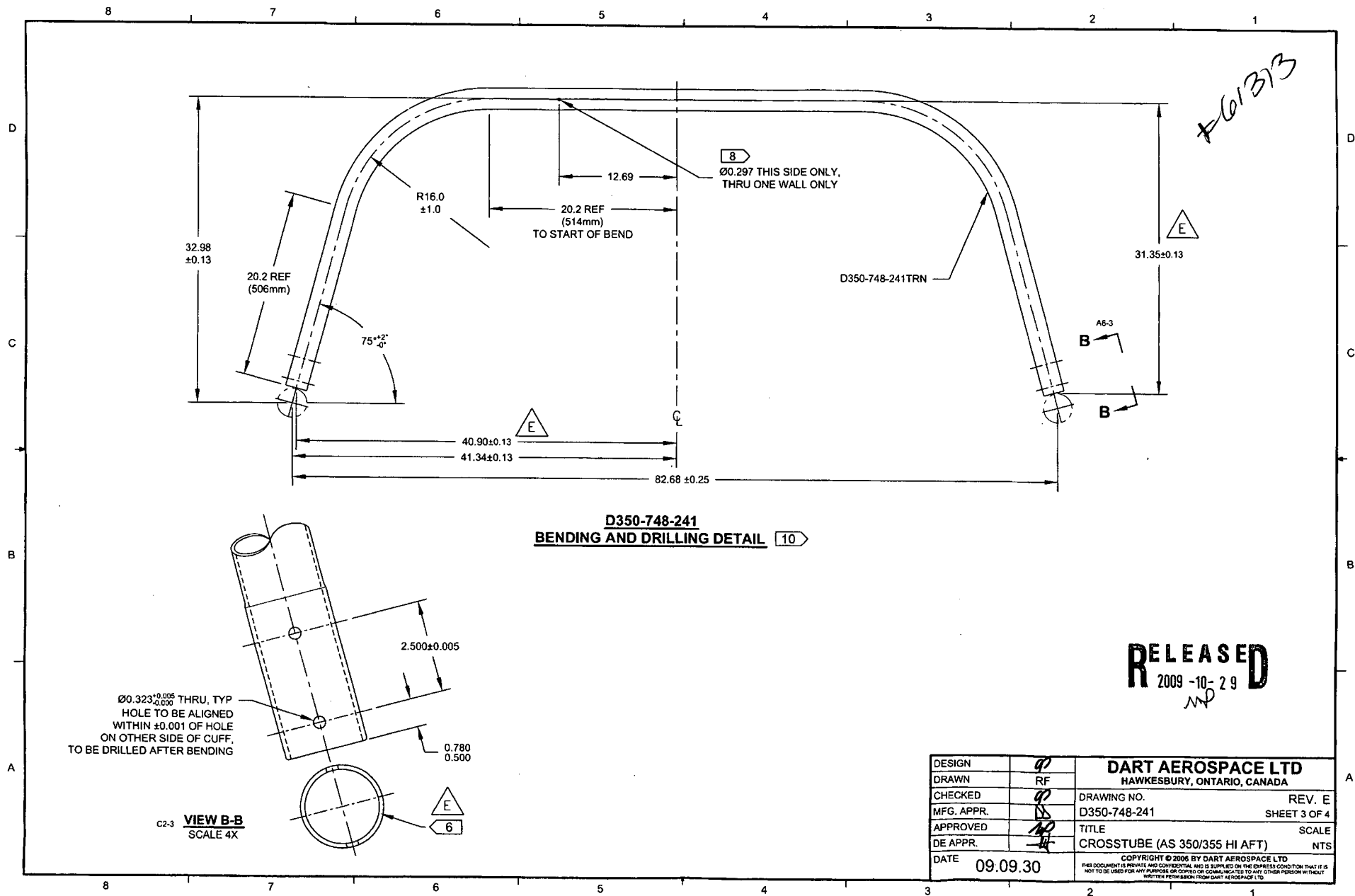
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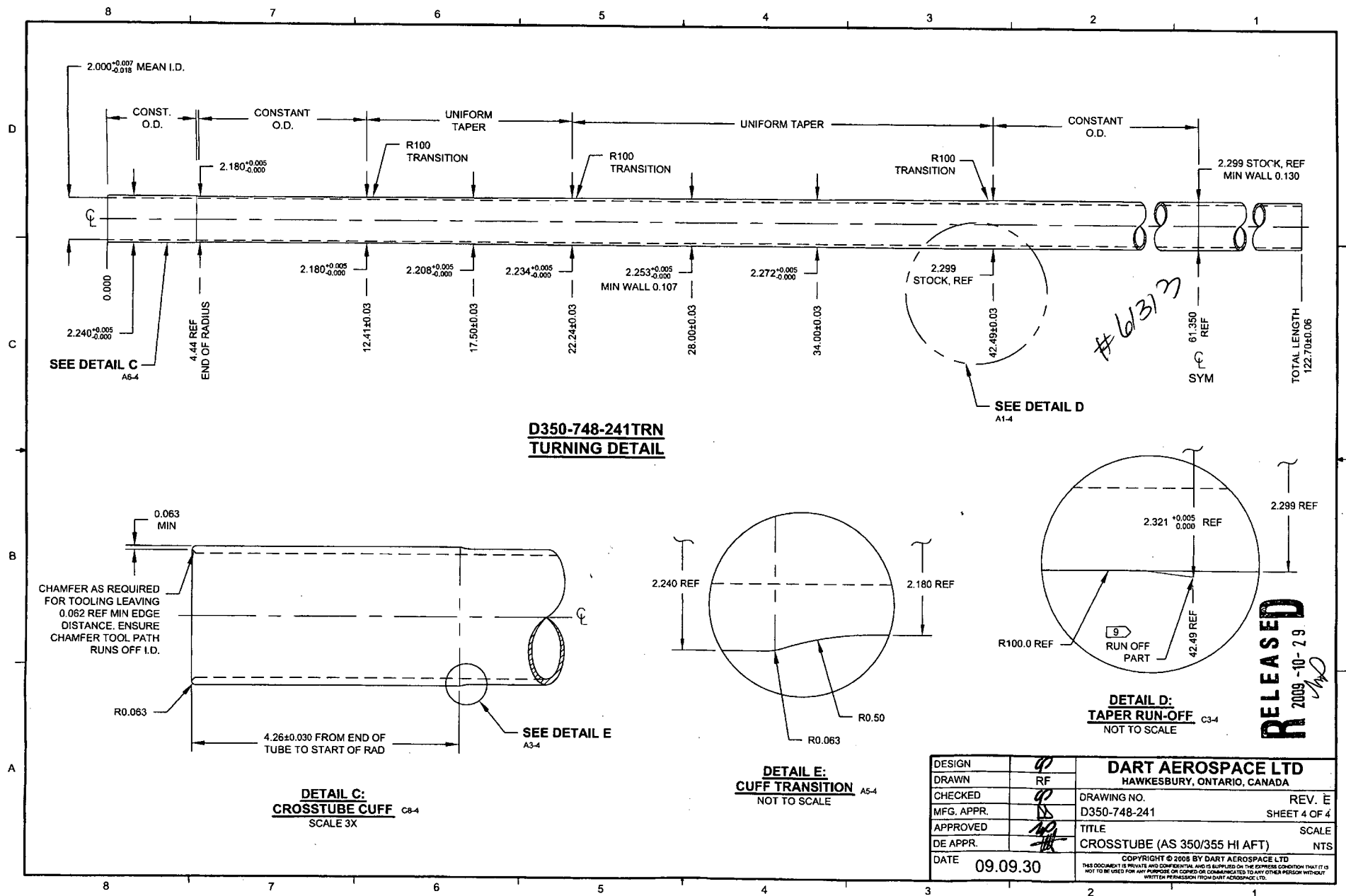
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VAC AERO
INTERNATIONAL INC.

RELEASE NOTE

GST No.: R105468102

OAK 123636-1



HEAD OFFICE
1371 SPEERS ROAD, OAKVILLE, ONTARIO
CANADA L6L 2X5
TEL: (905) 827-4171 FAX: (905) 827-7489



2009 WYECROFT ROAD, UNIT B
OAKVILLE, ONTARIO
CANADA L6L 6J4
TEL: (905) 827-7377 FAX: (905) 827-1380



QUEBEC DIVISION
7450 RUE VERITE STREET, ST. LAURENT, QUEBEC
CANADA H4S 1C5
TEL: (514) 334-4240 FAX: (514) 334-6269

10/27/2010

MM / DD / YYYY

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1DAR01

BILL TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

SHIP TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
10/27/2010		ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
12699		NET 30 DAYS

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
D350-748	-141/-121 TRN	EA	11	11	
<p>Process Specifications: Procedure: 4353 HEAT TREATED TO 180 KSI MIN. PER AMS 2759-1E 100% HARDNESS CHECKED AS PER ASTM E-18 40/45 HRC MATERIAL: 4130</p> <p>8 10/11/10</p> <p>7 PIECES D530-748-141 TRN B61135, B61136, B61137, B61138, B61345, B61346, B61347</p> <p>4 PIECES D350-748-241 TRN B61313, B61315, B61316, B61314</p>					
<div>100% HARDNESS TESTED Qty: 11 Pcs 44/45 HRC 2702/10 VALO TH 29 Q.C.</div>					

I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.



METAL TREATING INSTITUTE

Authorized Q.C. Inspector



VACUUM BRAZING - HEAT TREATING - SPECIAL PROCESSING - FURNACE EQUIPMENT
TURBINE COMPONENT OVERHAUL - PLASMA AND OTHER COATINGS